

5/24

DART AEROSPACE LTD	Work Order:	23579
Description: Plug 03.12.14	Part Number:	D2651-1
Drawing: D2651 Rev.A+B	Qty:	500

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	JK	05.06.16	500
2	CNC CELL	Machine as per folio FA219 Material: 6061-T6(QQ-A-225/8) or equivalent. .500" Dia Batch <u>71691</u> <u>M13466</u>	J.G	05/06/20	500
3	QC	Inspect level 2	J.G	05/06/20	500
4	QC	Inspect level 8	PC	05-06-20	500
5	METAL	Deburr and tumbler	ML	05-06-27	495
6	QC	Inspect Level 5	J	05-07-01	454
7	FINISHING	Acid etch and alodine per QSI 005 4.1	ML	05-07-01	495
8	FINISHING	Powder coat gloss white (Ref: 4.3.5.1) per QSI 005 4.3 (Only larger section necessary)	FC	05-08-02	495
9	STORES	Identify and Stock	FC	05-08-02	495
10	EXPEDITING	Close W/O Inspect level 21 Cost / Part .70 ^{5.95} 05/08/16 (495)	(G)	05/08/16	495

Rev	Date	Change	Revised By	Approved
A	02.04.15	New Issue	NG	02-04-15

RELEASED

02/04/15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-06-20 2/3		• Total length of plug is 0.009 over tol. (0.394"), are parts acceptable Qty 500	CP 05-06-20	Acceptable this time	05-06-20 05-06-21	2 05-06-20	CP 05-06-21 per QSI 042	2 05-06-20
05-06-21 5		Find the box done. We have to re-do the step 5	AB 05-06-21	No Body sign the step. in order because there No Good and sign	AB 05-06-21 05-06-27	AB 05-06-27	AB 05-06-27	2 05-06-27
05-07-04 6		1 plug found too short by 0.045	AB 05-07-04	SCRAP	2 05-07-04	2 05-07-04	AB 05-07-04	2 05-07-04

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

No

DQA: 15Date: 05/08/02

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

DART AEROSPACE LTD	Work Order:	23579
Description: Plug	Part Number:	D2651-1
Inspection Dwg: D2651	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>S. G</u>	Audited by: <u>C</u>	Prototype Approval: <u>N/A</u>
Date: <u>05/06/22</u>	Date: <u>05.06.22</u>	Date: <u>WIP</u>

Rev	Date	Change	Revised by	Approved
A	03.12.22	New Issue	KJ/RF	KE

RELEASED

04.01.14 - B1



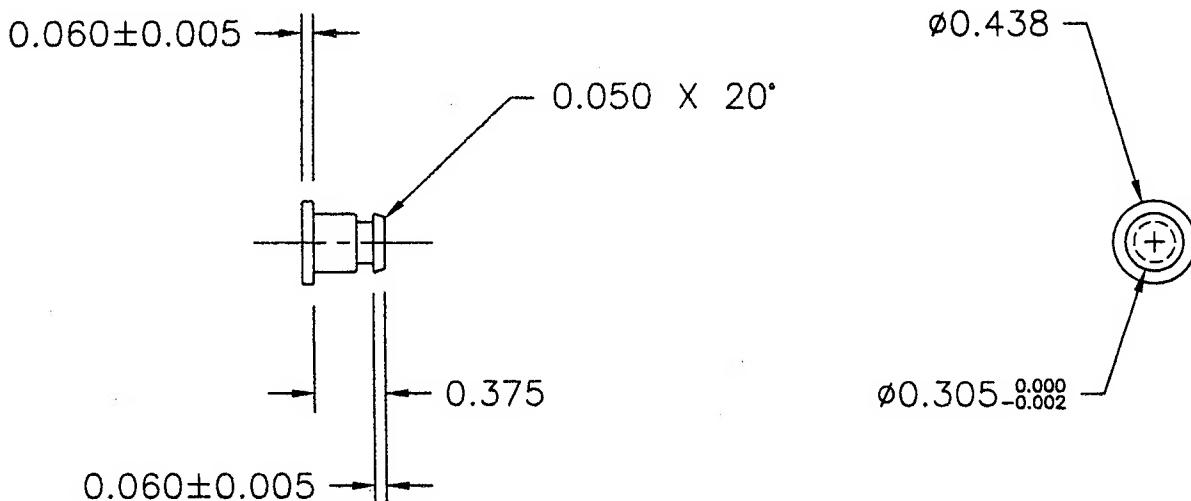
1 COPY ISSUE
DATE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2651	SHEET 1 OF 1
DATE		TITLE	SCALE
03.12.19		PLUG	1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

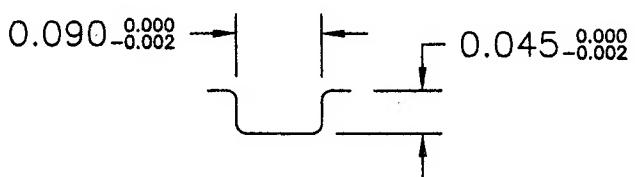
RELEASED

03.12.19

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1) SMOOTH COPY
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1 RETURN TO
- 3) POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 ENGINEERING
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED UNCONTROLLED COPY
- 5) ALL DIMENSIONS ARE IN INCHES S.J.C. DT T. AMENDMENT
- 6) BREAK ALL SHARP EDGES 0.010 MAX THCUT NOTICE

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

WORK ORDER

NO. 23579

Job Costing Report

Dart Aerospace Ltd.
HawkesburyJun 16, 2005
08:04 am

Work Order No : 0023579
 Project Name : D2651-1
 Project For : WK524
 Work Order Type : Main
 Main WO Number :
 House Part Number : D2651-1
 Description : Plug
 Manufactured : Yes
 Amount Req'd : 500
 Amount Done : 0
 Start Date : 06-15-05
 Est Finish Date : 06-24-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00

Est Mark Up : 0.000%
 Actual Mark Up : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
=====		=====	=====		
Burden :	0.00	0.00	0.00		
=====		=====	=====		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00

Chris Provencal

From: "David Shepherd" <davids@dartaero.com>
To: "Chris Provencal" <chrisp@dartaero.com>
Sent: June 21, 2005 12:24 PM
Subject: Re: D2651-1 plug problem

0.394 is acceptable

----- Original Message -----

From: Chris Provencal
To: David Shepherd
Sent: Monday, June 20, 2005 1:08 PM
Subject: D2651-1 plug problem

D2651-1 plug (ie the o-ring plug for the 206 skidtubes), The parts are over tolerance by 0.009" (0.394") on the 0.375" dimension. Dan indicated that from his experience this shouldn't be a problem. I will send a fax of the dwg.

Sincerely,
Chris Provencal

DART Aerospace Ltd.

Email...chrisp@dartaero.com
Phone...613-632-3336
Fax.....613-632-4443